

83513

Thursday, April 19, 2012 10:26:44 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Pedal Lock Base

Start Date: 4/19/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/27/2012 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: 2019 Tooling:

Date: _____

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

100	Hardinge CNC LATHE SMALL	0.00		
100				
Hardinge	Memo	0.00		
Hardinge CNC Lathe Small	Machine D3368-1 as per Folio FA499 and Dwg D3368 Identify as D3368-1 Deburr		OK 12/06/29	5 10
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC	Memo	0.00		
Quality Control			OK 12/06/29	5 10
120	QC8- Inspect parts - second check	0.00		
120				
QC	Memo	0.00		
Quality Control			S.A 12/06/30	5 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83513

83513

Page 2

Thursday, April 19, 2012 10:26:44 AM

Item ID: D3370-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Base
 Start Date: 4/19/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:45 OVEN TEMPERATURE:								
	FINISH TIME: 3:20 F 4:15								
150	Identify as per dwg & Stock Location SI 490	0.00							
150									
Packaging	Memo	0.00							
Packaging									

5 76 12.73

5X 12/27/23

5x 80 12-7-3

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Work Order ID 83513***83513***

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Item ID: D3370-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pedal Lock Base

Start Date: 4/19/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/7/4 

12074

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Picklist Print

Thursday, April 19, 2012 10:26:48 AM

Page 1

Work Order ID: 83513

83513

Parent Item: D3370-1

D3370-1

Parent Item Name: Pedal Lock Base

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B05.05.25Added Powder CoatKJ/JLM
IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased		No		100	f	70.9900	0.3483	1.466526			

M6061T6B1 500X02 500

6061-T6 Bar 1.50 x 2.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	70.99	
103069	12	
→ 107387	22.99	
16742	36	

1.84 *on 12/06/28*

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83513
Description: Pedal Lock Base		Part Number:	D3370-1
Inspection Dwg: D3370	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	—		Vernier	
0.202	+/-0.010	.200	—		"	
0.592	+/-0.010	.590	—		"	
0.550	+/-0.010	.558	—		"	
0.760	+/-0.010	.769	—		"	
1.50	+/-0.030	1.500	—		"	
1.188	+/-0.010	1.190	—		"	
1.232	+/-0.010	1.232	—		"	
R0.500	+/-0.010	R.500	—		"	
2.35	+/-0.030	2.350	—		"	
1.920	+/-0.010	1.919	—		"	
0.450	+/-0.010	.449	—		"	
1.673	+/-0.010	1.671	—		"	
2.638	+/-0.010	2.636	—		"	
4.00	+/-0.030	4.000	—		"	
Ø0.203	+0.005/-0.000	Ø.204	—		"	
0.250	+/-0.030	.235	—		"	
1.450	+/-0.005	1.450	—		"	
0.450	+/-0.010	.450	—		"	
15°	+/-0.1°	15°	—		"	

Measured by:	ank	Audited by:	D.A.	Prototype Approval:	N/A
Date:	12/06/29	Date:	12/06/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	

Dart Aerospace Ltd

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• **NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

△C

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
	1	D2728-7	LABEL
	1	D3370-1	BASE
	1	D3370-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0 50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83513
2012-04-19

RELEASED
08-07-16

C	SHEET 1 ADDED P/L ADDED -041 TO P/L (SEE NCR 264) DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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8 7 6 5 4 3 2 1

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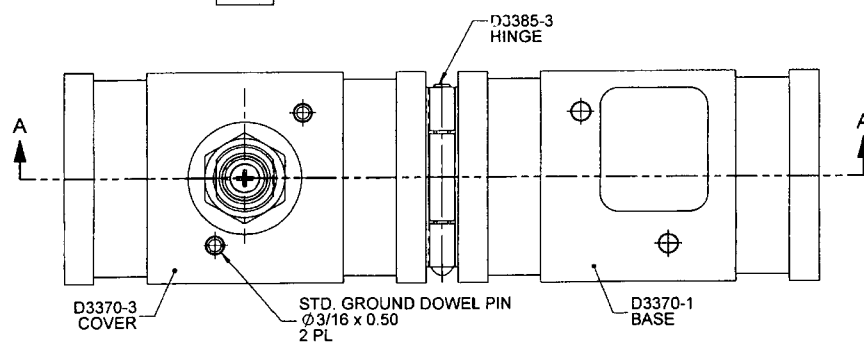
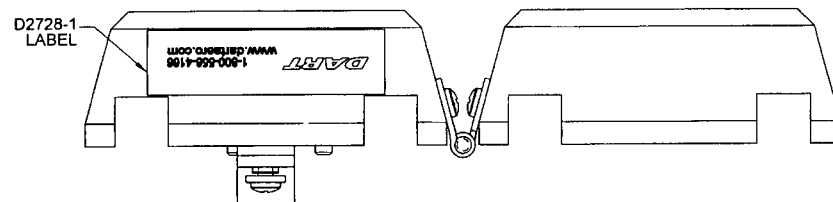
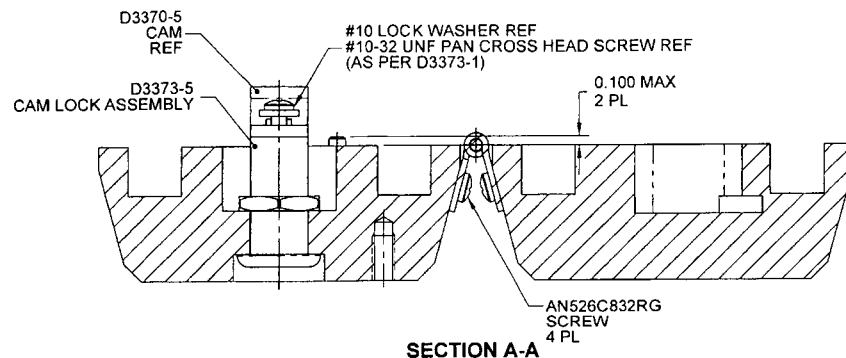
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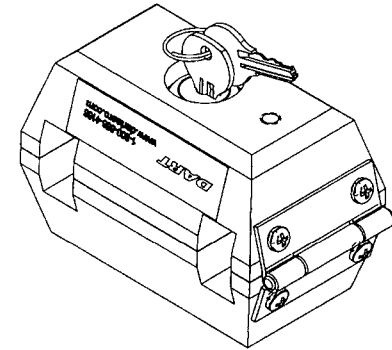
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D3370-051 PEDAL LOCK ASSEMBLY

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.75 lbs



83513

RELEASED
08-07-11

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	S	DRAWING NO	REV. C
MFG. APPR.	EZ	D3370	SHEET 2 OF 4
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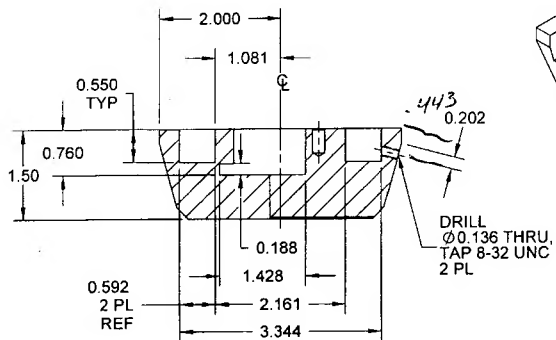
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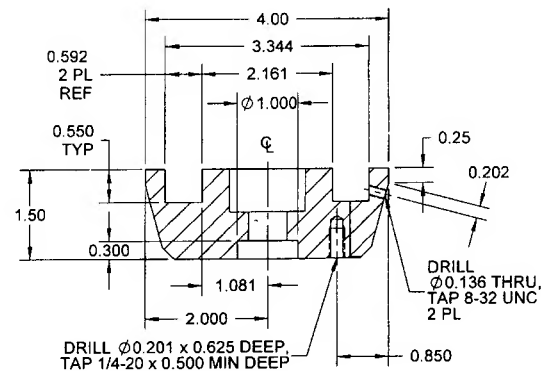
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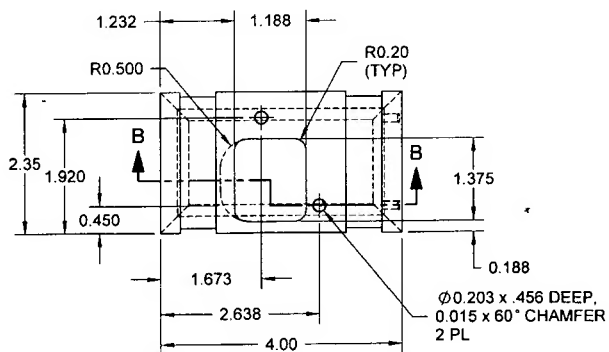
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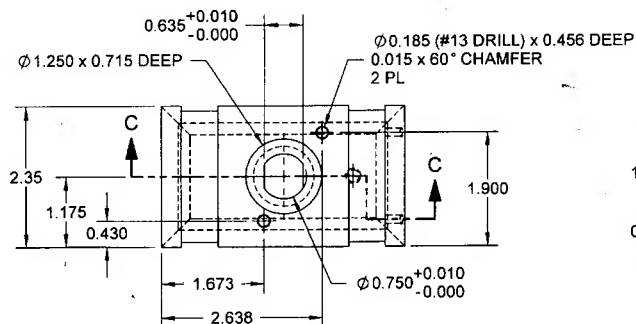
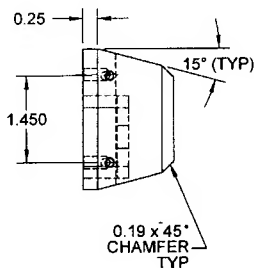
SECTION B-B



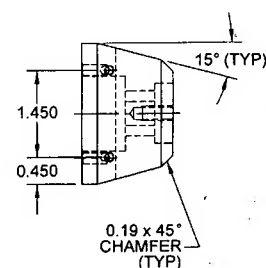
SECTION C-C



D3370-1 BASE



D3370-3 COVER



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
REF. DART SPEC. M6061T66
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

83513

RELEASED
09-07-16

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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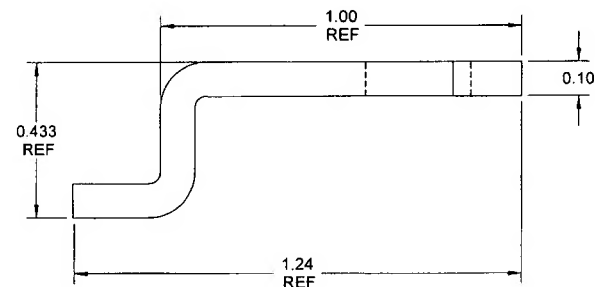
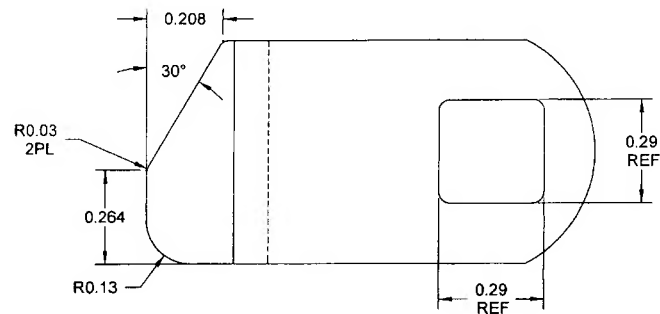
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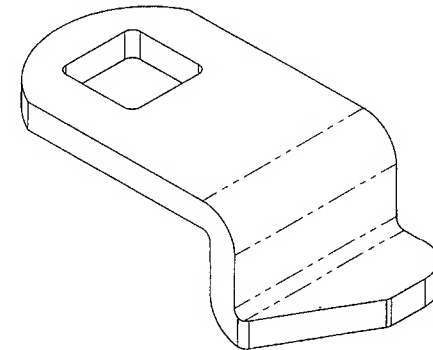
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NOTE: Date & initial all entries



D3370-5 CAM



88513

RELEASED
780714

- NOTES:**
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
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